



Dart Aerospace Ltd.  
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Canada

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**RBW109-3101-14-1**  
**Job Sheet 199526**



**Part No:** RBW109-3101-14-1

**Job Qty:** 1 pcs

**Part Name:** Main Rotor Blade Trim Tab Gauge



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 8/27/19

**Job Tracking No:**

**Due Date:** 10/18/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG RBW109-3101-14-1 Rev 2 IPP Rev. A 19.08.16 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                         |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------------------------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                  |
| 100   | Small Fab - 1               | 1 pcs | 10/18/19   |          | 0.00      | 0.20    | Small Fab - 1         |           | MLL                              |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 8         |           |                                  |
| 110   | QC 5                        | 1 pcs | 10/18/19   |          | 0.00      | 0.00    | QC 5 - 10             |           | DAS<br>OCT 28 2019<br>68<br>9-89 |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 40             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 61             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 81             |           |                                  |
| 120   | Packaging 3-1 - Stock - B4B | 1 pcs | 10/18/19   |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |                                  |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |                                  |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |                                  |
|       |                             |       |            |          |           |         | Packaging 3 - 4 - B4B |           |                                  |



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**Container No:** S226653



**Part:** RBW109-3101-14-1

**Job No:** 199526

**Serial No/Batch:** S226653

**Revision:** 2

**Inspector:**

**Exp Date:**

**Instructions:**

**Date:** 10/25/19

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|                |       |          |           |                        |      |
|----------------|-------|----------|-----------|------------------------|------|
|                |       |          |           | Packaging 3 - 5 - B4B  | DAS  |
|                |       |          |           | Packaging 3 - 6 - B4B  | 28   |
|                |       |          |           | Packaging 3 - 7 - B4B  | 9-89 |
|                |       |          |           | Packaging 3 - 8 - B4B  |      |
|                |       |          |           | Packaging 3 - 9 - B4B  |      |
|                |       |          |           | Packaging 3 - 10 - B4B |      |
|                |       |          |           | Packaging 3 - 11 - B4B |      |
|                |       |          |           | Packaging 3 - 12 - B4B |      |
|                |       |          |           | Packaging 3 - 13 - B4B |      |
|                |       |          |           | Packaging 3 - 14 - B4B |      |
|                |       |          |           | Packaging 3 - 15 - B4B |      |
|                |       |          |           | Packaging 3 - 16 - B4B |      |
|                |       |          |           | Packaging 3 - 17 - B4B |      |
|                |       |          |           | Packaging 3 - 18 - B4B |      |
|                |       |          |           | Packaging 3 - 19 - B4B |      |
|                |       |          |           | Packaging 3 - 20 - B4B |      |
|                |       |          |           | Packaging 3 - 21 - B4B |      |
|                |       |          |           | Packaging 3 - 22 - B4B |      |
|                |       |          |           | Packaging 3 - 23 - B4B |      |
|                |       |          |           | Packaging 3 - 24 - B4B |      |
|                |       |          |           | Packaging 3 - 25 - B4B |      |
|                |       |          |           | Packaging 3 - 26 - B4B |      |
|                |       |          |           | Packaging 3 - 27 - B4B |      |
|                |       |          |           | Packaging 3 - 28 - B4B |      |
|                |       |          |           | Packaging 3 - 29 - B4B |      |
|                |       |          |           | Packaging 3 - 30 - B4B |      |
|                |       |          |           | Packaging 3 - 31 - B4B |      |
|                |       |          |           | Packaging 3 - 32 - B4B |      |
|                |       |          |           | Packaging 3 - 33 - B4B |      |
|                |       |          |           | Packaging 3 - 34 - B4B |      |
|                |       |          |           | Packaging 3 - 35 - B4B |      |
|                |       |          |           | Packaging 3 - 36 - B4B |      |
| 130 QC 21 - FG | 1 pcs | 10/18/19 | 0.00 0.00 | QC 21 - FG - 21        |      |
|                |       |          |           | QC 21 - FG - 70        |      |
|                |       |          |           | QC 21 - SA - 53        |      |

Part Op 100 - Assemble as per DWG.  
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O  
 120 - Identify as per dwg & Stock Location: \_\_\_\_\_  
 130 - QC21- Final Inspection - Work Order Release

OCT 29 2019

GA/B7A

## Job BOM

| Part / Item              | Component Name                                   | Quantity     | Operation         | Container |
|--------------------------|--------------------------------------------------|--------------|-------------------|-----------|
| 66 90272A830             | Phillips Pan Head Screw, #10-32 UNF -2A X 5/8    | 2 (2 ea)     | 100-Small Fab - 1 | 5210634   |
| 63 90273A192             | Steel Phillips Flat Head Screw #8-32 x 3/8" Long | 4 Ea (4 ea)  | 100-Small Fab - 1 | 5110442   |
| 29 90273A197             | Phillips Flat Head Screw                         | 2 (2 ea)     | 100-Small Fab - 1 | 5210623   |
| 29 90279A201             | Phillips Round Head Screw, 8-32 UNC -2A X 1-1/4  | 4 (4 ea)     | 100-Small Fab - 1 | 5210631   |
| 30 90480A195             | Zinc Plated Steel Hex Nut #10-32 X 1/8" Height   | 2 Ea (2 ea)  | 100-Small Fab - 1 | 5210609   |
| 30 94135K23              | Spring, Ø0.048 X Ø3/8 X 5.05 Ext Length          | 2 (2 ea)     | 100-Small Fab - 1 | 5210621   |
| 30 98023A113             | Flat Washer, #8                                  | 2 (2 ea)     | 100-Small Fab - 1 | 5210616   |
| 43 98032A469             | Flat Washer, #10                                 | 5 (5 ea)     | 100-Small Fab - 1 | 5210618   |
| 137A RBW109-3101-14-1-01 | Frame Top                                        | 1 pcs (1 ea) | 100-Small Fab - 1 | 5219098   |
| " RBW109-3101-14-1-03    | Frame Bottom                                     | 1 pcs (1 ea) | 100-Small Fab - 1 | 5217607   |
| 1410 RBW109-3101-14-1-05 | Flat Scissor Bar                                 | 1 pcs (1 ea) | 100-Small Fab - 1 | 5212058   |
| 106 RBW109-3101-14-1-07  | Bent Scissor Bar                                 | 1 pcs (1 ea) | 100-Small Fab - 1 | 5217213   |
| 1410 RBW109-3101-14-1-09 | Standoff                                         | 1 pcs (1 ea) | 100-Small Fab - 1 | 5218118   |
| " RBW109-3101-14-1-11    | Center Brace                                     | 1 pcs (1 ea) | 100-Small Fab - 1 | 5218944   |
| 141F RBW109-3101-14-1-13 | Gage Plate                                       | 1 pcs (1 ea) | 100-Small Fab - 1 | 5212056   |
| 1410 RBW109-3101-14-1-15 | Spring Pin                                       | 1 pcs (1 ea) | 100-Small Fab - 1 | 5215826   |
| " RBW109-3101-14-1-17    | Clamp Pad                                        | 2 pcs (2 ea) | 100-Small Fab - 1 | 5210999   |
| " RBW109-3101-14-1-19    | Stop                                             | 1 pcs (1 ea) | 100-Small Fab - 1 | 5213776   |
| 103 RBW109-3101-14-1-21  | Pad                                              | 2 pcs (2 ea) | 100-Small Fab - 1 | 5212106   |
| 141D RBW109-3101-14-1-23 | Phillips Round Head Screw                        | 1 pcs (1 ea) | 100-Small Fab - 1 | 5221513   |

012635

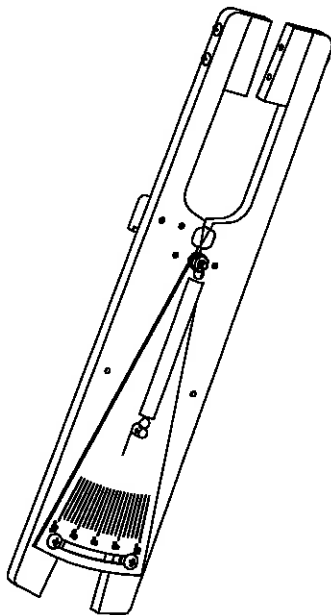
## Job Allocations

| Operation         | Component Part      | Required | Inventory | Allocated |
|-------------------|---------------------|----------|-----------|-----------|
| 100-Small Fab - 1 | 90272A830           | 2        | 0         | 0         |
|                   | 90273A192           | 4        | 100       | 0         |
|                   | 90273A197           | 2        | 0         | 0         |
|                   | 90279A201           | 4        | 0         | 0         |
|                   | 90480A195           | 2        | 0         | 0         |
|                   | 94135K23            | 2        | 0         | 0         |
|                   | 98023A113           | 2        | 0         | 0         |
|                   | 98032A469           | 5        | 0         | 0         |
|                   | RBW109-3101-14-1-01 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-03 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-05 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-07 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-09 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-11 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-13 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-15 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-17 | 2        | 0         | 0         |
|                   | RBW109-3101-14-1-19 | 1        | 0         | 0         |
|                   | RBW109-3101-14-1-21 | 2        | 0         | 0         |
|                   | RBW109-3101-14-1-23 | 1        | 0         | 0         |

## Part Specifications

Specifications could not be found.

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[illegible]

| ASST<br>QTY | B/O | Part # | Description                | Material     | B/O INFORMATION OR SPECIFICATIONS                    | PQ. |
|-------------|-----|--------|----------------------------|--------------|------------------------------------------------------|-----|
|             |     | 421    | 1 FRAME TOP                | 6061         |                                                      | 2   |
|             |     | 423    | 1 FRAME BOTTOM             | 6061         |                                                      | 3   |
|             |     | 426    | 1 PLAT SCISSOR BAR         | 6061         |                                                      | 4   |
|             |     | 427    | 1 BENT SCISSOR BAR         | 6061         |                                                      | 5   |
|             |     | 429    | 1 STANDOFF                 | 304 S.S.     |                                                      | 6   |
|             |     | 431    | 1 CENTER BRACE             | 6061         |                                                      | 7   |
|             |     | 433    | 1 GAGE PLATE               | 6061         |                                                      | 8   |
|             |     | 435    | 1 SPRING PIN               | 6061         |                                                      | 9   |
|             |     | 437    | 2 CLAMP PAD                | WHITE DELRIN |                                                      | 10  |
|             |     | 439    | 1 STOP                     | WHITE DELRIN |                                                      | 11  |
|             |     | 441    | 2 PAD                      | BLACK RUBBER |                                                      | 12  |
|             |     | 443    | 1 PHILLIPS RND HEAD SCREW  | S.S.         | 10-32 UNC -2A X 1 (MCMASTER-CARR #91725A83) MODIFIED | 13  |
|             | B/O | 445    | 5 PLAT WASHER              | STEEL        | #10 (MCMASTER-CARR #90320A49)                        | 1   |
|             | B/O | 447    | 2 HEX NUT                  | STEEL        | #10-32 UNC -2B (MCMASTER-CARR #90641A19)             | 1   |
|             | B/O | 449    | 4 PHILLIPS RND HEAD SCREW  | STEEL        | 4-40 UNC -2A X 1/4 (MCMASTER-CARR #90279A20)         | 1   |
|             | B/O | 451    | 4 PHILLIPS FLAT HEAD SCREW | STEEL        | 4-40 UNC -2A X 3/8 (MCMASTER-CARR #90273A192)        | 1   |
|             | B/O | 453    | 2 PHILLIPS FLAT HEAD SCREW | STEEL        | 4-40 UNC -2A X 3/4 (MCMASTER-CARR #90274A191)        | 1   |
|             | B/O | 455    | 2 PHILLIPS PAN HEAD SCREW  | STEEL        | #10-32 UNC -2A X 5/8 (MCMASTER-CARR #90272A80)       | 1   |
|             | B/O | 457    | 2 SPRING                   | S.S.         | 10-48 X 8/16 X 5/8 EXT LG. (MCMASTER-CARR #94138A23) | 1   |
|             | B/O | 459    | 2 R 1/2 WASHER             | STEEL        | #8 (MCMASTER-CARR #90523A113)                        | 1   |

1. APPLY LOCTITE 242 FROM BACKSIDE, ENSURING ASSY. ROTATES FREELY.
2. USE APPROPRIATE ADHESIVE TO ASSEMBLE -21 TO -01 AND -21 TO -03.

**DART**  
AEROSPACE

| TITLE                    |
|--------------------------|
| M/R BLADE TRIM TAB GUAGE |

|                              |                                      |     |   |
|------------------------------|--------------------------------------|-----|---|
| UNSW. NO.                    | RBW109-3101-14-1                     | REV | 2 |
| MAT'L                        | DRAWN BY: PERRITT                    |     |   |
| UNLESS OTHERWISE SPECIFIED   | APPROVED <i>P. Perritt</i>           |     |   |
| ALL DIMENSIONS ARE IN INCHES | FRACTIONS & 16                       |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 32                        |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 64                        |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 128                       |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 256                       |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 512                       |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 1024                      |     |   |
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| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 131072                    |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 262144                    |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 524288                    |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 1048576                   |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 2097152                   |     |   |
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| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 8388608                   |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 16777216                  |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 33554432                  |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 67108864                  |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 134217728                 |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 268435456                 |     |   |
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| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 68719476736               |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 137438953472              |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 274877906944              |     |   |
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| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 35184372088832            |     |   |
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| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 18446744073709551616      |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 36893488147419103232      |     |   |
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| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 147573952589676412928     |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 295147905179352825856     |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 590295810358705651712     |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 1180591620717411303424    |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 2361183241434822606848    |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 4722366482869645213696    |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 9444732965739290427392    |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 18889465931478580854784   |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 37778931862957161709568   |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 75557863725914323419136   |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 151115727451828646838272  |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 302231454903657293676544  |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 604462909807314587353088  |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 1208925819614629174706176 |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 2417851639229258349412352 |     |   |
| ALL DIMENSIONS ARE IN INCHES | DECIMALS & 4835703278458516          |     |   |



Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. \_\_\_\_\_

Job: \_\_\_\_\_

Part No. \_\_\_\_\_

### DISPOSITION

Rework ☐  
Scrap ☐  
Use-as-is ☐

### DEPARTMENT/PROCESS

Skid-tube ☐  
Machining ☐  
Large Fab ☐

Cross tube ☐  
Small Fab ☐  
Finishing ☐

Eng. (Non-AW) ☐  
Prod. Eng. Coord. ☐  
Rec/Store/Packaging ☐

Engineering ☐  
Water Jet ☐  
Supplier ☐  
Quality ☐

Date: \_\_\_\_\_

Sequence #: \_\_\_\_\_

QTY Affected: \_\_\_\_\_

MRB (QSI042)

### Description Work Order Deviation

### Disposition

Completed By \_\_\_\_\_

Lead hand / Supervisor \_\_\_\_\_

QC / QA Coordinator \_\_\_\_\_

### Root Cause

Operator ☐  
Manufacturing Process ☐  
Equip/Tooling ☐  
Handling/Preservation ☐  
Material ☐  
Product Improvement ☐  
Process Improvement ☐  
Human Factors ☐

### FAULT CATEGORY

| Pressure/Forced              | Contamination                   | Power Loss/Surge         | Positioned Wrong         |
|------------------------------|---------------------------------|--------------------------|--------------------------|
| <input type="checkbox"/>     | <input type="checkbox"/>        | <input type="checkbox"/> | <input type="checkbox"/> |
| Bending                      | Misaligned/off center           | Folio/Program            | Outside Tolerance        |
| <input type="checkbox"/>     | <input type="checkbox"/>        | <input type="checkbox"/> | <input type="checkbox"/> |
| Crushing                     | BOM/Route                       | Grain Direction          | Drawing                  |
| <input type="checkbox"/>     | <input type="checkbox"/>        | <input type="checkbox"/> | <input type="checkbox"/> |
| Cracks                       | Broken/Damage/Defect            | Weld                     | Finish                   |
| <input type="checkbox"/>     | <input type="checkbox"/>        | <input type="checkbox"/> | <input type="checkbox"/> |
| Crimp/Kink/Ripple/Wave/Twist | Incomplete/Unclear Instructions | Wrong Stock Pulled       | Part Lost/Missing        |
| <input type="checkbox"/>     | <input type="checkbox"/>        | <input type="checkbox"/> | <input type="checkbox"/> |
| Marks/Chatter                | Drill Holes                     | Out of Sequence          | Misread                  |
| <input type="checkbox"/>     | <input type="checkbox"/>        | <input type="checkbox"/> | <input type="checkbox"/> |
| Mislabeled                   | Fit/Function                    | Off-set/Set-up           |                          |
| <input type="checkbox"/>     | <input type="checkbox"/>        | <input type="checkbox"/> |                          |

Other/Details: \_\_\_\_\_